

TECHNICAL DATASHEET

2.704.8016
WATERBORNE EPOXY PRIMER

PRODUCT DESCRIPTION

2.704.8016 Waterborne Epoxy Primer, is a Light Grey (RAL 7032), 2-pack primer with high filling and good anticorrosion properties, good adhesion to different substrates.
It is a fast drying and easy application product as a solvent-based 2K epoxy primer.
It is recommended to protect the carpentry in general, industrial equipment and machinery.
1.959.8450 (9-450) Hardener must be properly shaken before use

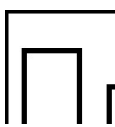
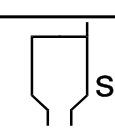




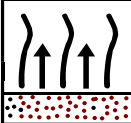
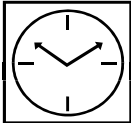
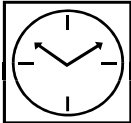


SELECTION AND PREPARATION OF SUBSTRATES

- Bare steel degreased, sanded, shot blasted, galvanized
- Light alloys
- Old finishes in good state and sanded

Do not use over wash primers or synthetic primers.

APPLICATION GUIDE

		CONVENTIONAL	AIRMIX
	Mixing ratio (by weight):	Epoxy primer 1000 Hardener 9-450 170	Epoxy primer 1000 Hardener 9-450 170
	Mixing ratio (by volume):	Epoxy primer 5 Hardener 9-450 1	Epoxy primer 5 Hardener 9-450 1
		HARDENER 9-450 MUST BE PROPERLY SHAKEN BEFORE USE	HARDENER 9-450 MUST BE PROPERLY SHAKEN BEFORE USE
	Thinning:	23-25% with tap water	6-15% with tap water
	Pot life at 20°C:	1.5 - 2 hours	1.5 - 2 hours
	Spray viscosity:	30-40 sec DIN4 at 20°C After mixing allow to stand for at least 5 minutes before checking viscosity	>60 sec DIN4 at 20°C After mixing allow to stand for at least 5 minutes before checking viscosity
	Spray gun set up:	1.6 - 1.8 mm	9 / 11 thou
	Spray pressure:	3 - 4 bar	70 - 100 bar
	Number of coats:	2 - 3	1 light dry coat + 1 wet coat

 <p><i>Flash off between coats:</i></p>	15 min or until matt	15 min or until matt
	20 min or until matt	20 min or until matt
 <p><i>Drying times (Depending on thickness and temperature):</i></p>	50 minutes / 60°C	50 minutes / 60°C
 <p><i>Dust free:</i></p>	15-20 min	20-30 min
	24 hours	24 hours
 <p><i>Recommended thickness:</i></p>	40-60 microns	60-80 microns
 <p><i>Overcoat time:</i></p>	Always possible without flattening after completed drying.	Always possible without flattening after completed drying.

TECHNICAL DATA

Theoretical coverage: 7 m²/l ready to spray giving 50µm dry film thickness

Storage: STORE FREE FROM FROST ABOVE 4°C.
Prolonged exposure to high temperatures or direct sources of heat should be avoided

HEALTH AND SAFETY

These products are for professional painting only, and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose. For Health and Safety information please refer to the material Safety Data Sheet, also available at: <http://corporateportal.ppg.com/Refinish/Selemix>

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